

# Work Order ID 84002

\*84002\*

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May-01-12 10:37:35 AM

Item ID: D119-675-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step LH

Start Date: 01/05/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/05/01*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675011 CHG004

*JBS 12/06/15*

*HJ for MLJ 12-6-15 (4)*

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

*4*

*12/06/15 JB*

120

QC4- 100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control

*S17/06/15*

*44*

*3043-041.84004.XH.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84002

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Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step LH

Start Date: 01/05/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

\*130\*

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-675-011

Location: 82

(4)

12/6/18 y

140

0.00

\*140\*

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

Done

12/6/19 J

MF  
12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 84002

\*84002\*

Parent Item: D119-675-011

\*D119-675-011\*

Parent Item Name: Heli-Access-Step LH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01  
IPP RevE change at rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3043-041		Manufactured	No			110	Each	0.0000	0	4			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D3043-041\*

Step Weldment LH, A119

D2182B032		Manufactured	No			120	Each	14.0000	4	16			
-----------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

\*D2182B032\*

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

14

63469

4

73932

10

63469

D2274		Manufactured	No			120	Each	632.0000	8	32			
-------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

\*D2274\*

Radius Block

Location

Loc Qty

Loc Code

ST007

632

78233

22

81958

400

83258

210

81958

D2617-3		Manufactured	No			120	Each	20.0000	4	16			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

\*D2617-3\*

Bushing

Location

Loc Qty

Loc Code

FG

10

27991

10

ST012

10

76948

10

4x 76948

84004

20

20

12x84008 12/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84002

\*84002\*

Parent Item: D119-675-011

\*D119-675-011\*

Parent Item Name: Heli-Access-Step LH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

D2617-5

Manufactured No

120

Each

21.0000

8

32

\*D2617-5\*

Spacer

\*\*

18x 84007 JB

14x 85423

Location

Loc Qty

Loc Code

FG

10

31756

10

ST012

11

81814

11

D2732

Manufactured No

120

f

86.4153

1.066

4.264

\*D2732\*

Rubber Extrusion

\*\*

Location

Loc Qty

Loc Code

ST410

86.415299

70987

86.415299

D3041-1

Manufactured No

120

Each

23.0000

4

16

\*D3041-1\*

Clamp

\*\*

Location

Loc Qty

Loc Code

ST462

23

77050

1

79723

22

D3041-3

Manufactured No

120

Each

24.0000

2

8

\*D3041-3\*

Clamp

\*\*

Location

Loc Qty

Loc Code

ST462

24

51114

8

76997

16

79723

76697

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 84002

\*84002\*

\*D119-675-011\*

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3042-1 Manufactured No

120 Each

20.0000

4 16 ✓

\*\*

JB

SAL \*D3042-1\*  
Clamp

## Location

## Loc Qty

## Loc Code

ST457

20

77487

20

120

Each

244.0000

4 16 ✓

\*\*

JB

AN4-11A

Purchased

No

SAL \*AN4-11A\*  
Bolt

## Location

## Loc Qty

## Loc Code

ST356

244

118706

94

120731

100

121243

50

120

Each

667.0000

8 32 ✓

\*\*

JB 12/06/15

AN4-12A

Purchased

No

SAL \*AN4-12A\*  
Bolt

## Location

## Loc Qty

## Loc Code

ST357

667

115422

4

119775

50

120423

588

121524

25

120423

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84002

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step LH

\*84002\*

\*D119-675-011\*

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

120

Each

539.0000

16

✓

**\*AN4-15A\***

Bolt

\*\*

JB

## Location

## Loc Qty

## Loc Code

GA

100

120449

100

ST358

439

118706

3

119449

1

119749

19

120422

116

121444

100

121541

200

121541

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

30.0000

12

48

**\*AN960JD416\***

Washer

\*\*

121912

JB

## Location

## Loc Qty

## Loc Code

ST351

30

116289

10

119097

20

MS2104214

Purchased

No

120

Each

5,520.000

12

48

**\*MS210421 4\***

Nut

\*\*

JB

12/06/15

## Location

## Loc Qty

## Loc Code

ST300

5520

119075

520

121011

2000

121444

3000

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 <i>HELI-ACCESS-STEP™</i> , LH	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 <i>HELI-ACCESS-STEP™</i> , RH	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

## 5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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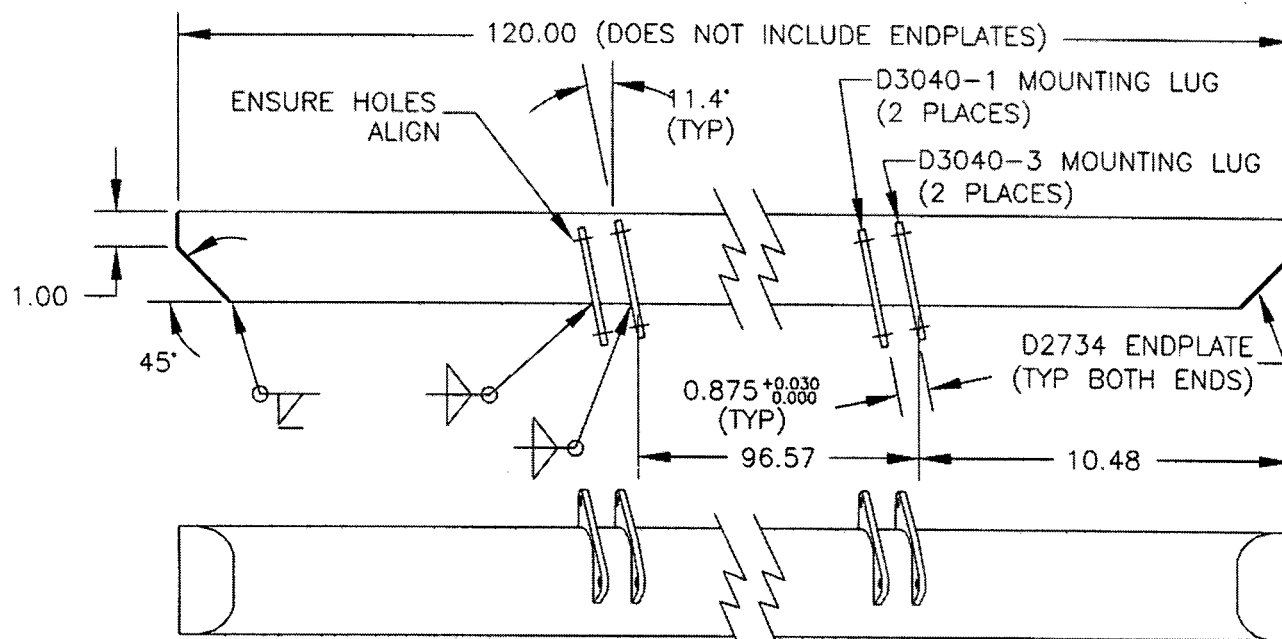
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Revision: 3

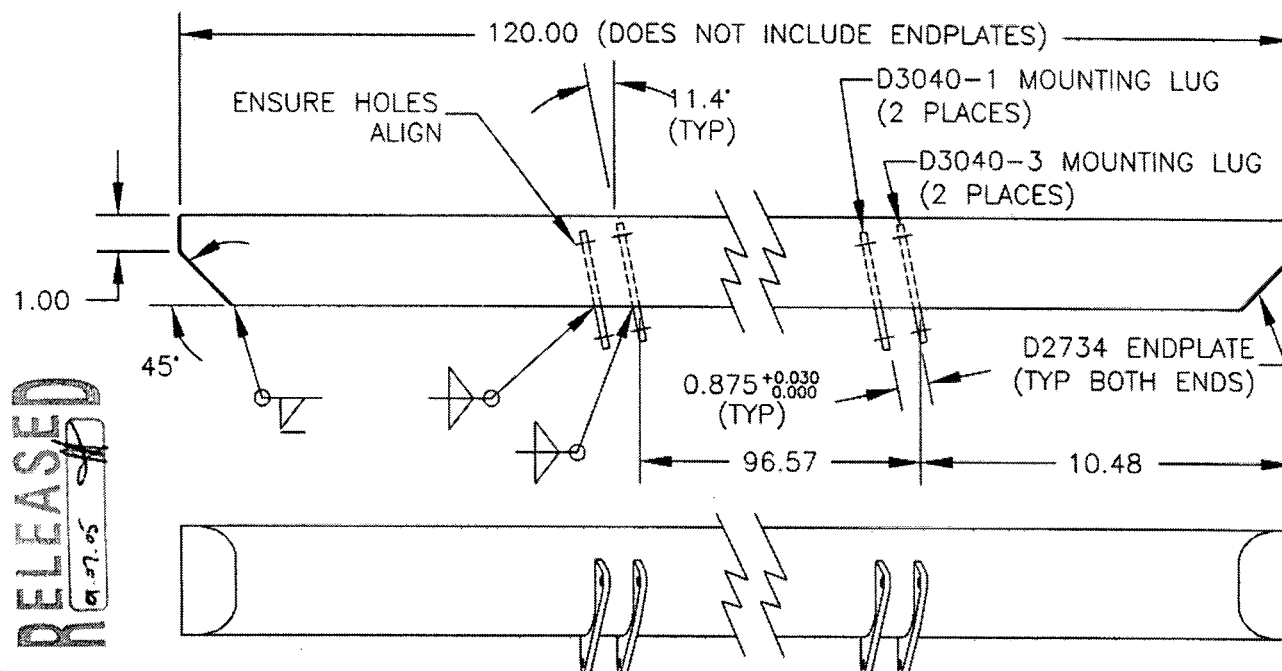
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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